

Work Order ID 77324

December 2, 2011 1:14:11 PM

Page 1

Item ID: D3215-3

Revision ID:

Item Name: Webbing Tidy

Start Date: 12/02/11 Start Qty: 60.00

Required Date: 12/07/11 Req'd Qty: 60.00

Reference:

Approvals: Process Plan: *(initials)*

Date: 11/12/11 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3215	Rev D
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100	
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100 FLOW WATER JET

Waterjet

FLOW CNC Waterjet

(initials)

Memo

1-Cut as per Dwg D3215 (D3215-3A)

Rev. *(initials)* 2-Deburr if necessary

0.00

Dwg Rev: *(initials)* Prog

3-Identify as D3215-3A

11-12-5

110	
-----	--

110 QC

Quality Control

QC2- Inspect parts off machine FAI/I/AIB

0.00

11-12-5

120	
-----	--

120 QC

Quality Control

QC8- Inspect parts - second check

0.00

0.00

11-12-5

(flow)

(initials)

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Item ID: D3215-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Webbing Tidy

Start Date: 12/02/11 Start Qty: 60.00

60

Required Date: 12/07/11 Req'd Qty: 60.00

60

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours
0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberReject
NumberInsp.
Stamp

130

130

Small Fab

Small Fab

Memo

0.00

1-Cut D3215-3B (2.130" x 0.530") as per dwg D32152-Deburr3-Identify
as D3215-3B

11-12-06

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

150

150

Brake NC

Brake NC

NC BRAKE

0.00

Memo

0.00

Form D3215-3A as per Dwg D3215

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Accept

N900040100

Setup

Start

NS1

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Start Date: 12/02/11 Start Qty: 60.00

60

Required Date: 12/07/11 Req'd Qty: 60.00

60

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center ID
160Operation
Description
QC5- Inspect part completeness to step on W/OSet Up/
Run Hours
0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp***160***

QC

Quality Control

Memo

Suzie 160

water

(84)

Ph →

170

170

Large Fab

Large Fab

0.00

Memo

0.00

Large Fab

Weld D3215-3 by joining D3215-3A and D3215-3B as per Dwg D3215 and QSI
004A/R AL ROD BATCH M14514 Identify as D3215-
3Grind flush

X32 11-12-13 JDL

180

180

QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

X32 2 RE 11-12-13

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Accept

N900040100

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60

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60

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center ID

190

190

QC

Quality Control

Operation
Description

QC5- Inspect part completeness to step on W/O

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

5/12/13

w/cont
Y32

200

200

Hand Finish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

32x8m-f 11/12/14

210

210

Powdercoat

Powder Coating

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

Memo

START TIME:

FINISH TIME:

4:00

0.00

OVEN TEMPERATURE:

320°F

4:30

32x8m-f 11/12/14

W115128

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Item ID: D3215-3

Accept

N900040100

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NS1

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Reference:

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

QC3- Inspect Part Finish

0.00

32

BK 11-12-K.

220

QC

Quality Control

Memo

0.00

230

230

Packaging

Packaging

0.00

41

11/12/20 32

Packaging

Memo

0.00

240

240

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/12/20 32

11/12/20
(32)

Picklist Print

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Work Order ID: 77324

Parent Item: D3215-3

Parent Item Name: Webbing Tidy

Start Date: 12/02/11

Required Date: 12/07/11

Comments: IPP A 04.01.06 New issue KJ/RF
 IPP Rev:B Now on Waterjet 06-07-03 JLM
 IPP rev C een 940 07.06.12 FC

Start Qty: 60.00

Required Qty: 60,00

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Cod</u>
MAT022	84.3	
117130	5.8	
119384 -	78.5	

M5052H32S.040
5052-1132 .040 Sheet

Purchased	No	130	sf	84,300
	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	
	MAT022	84.3		
	117130	5.8		
	119384	78.5		

0.0258 1,6294737

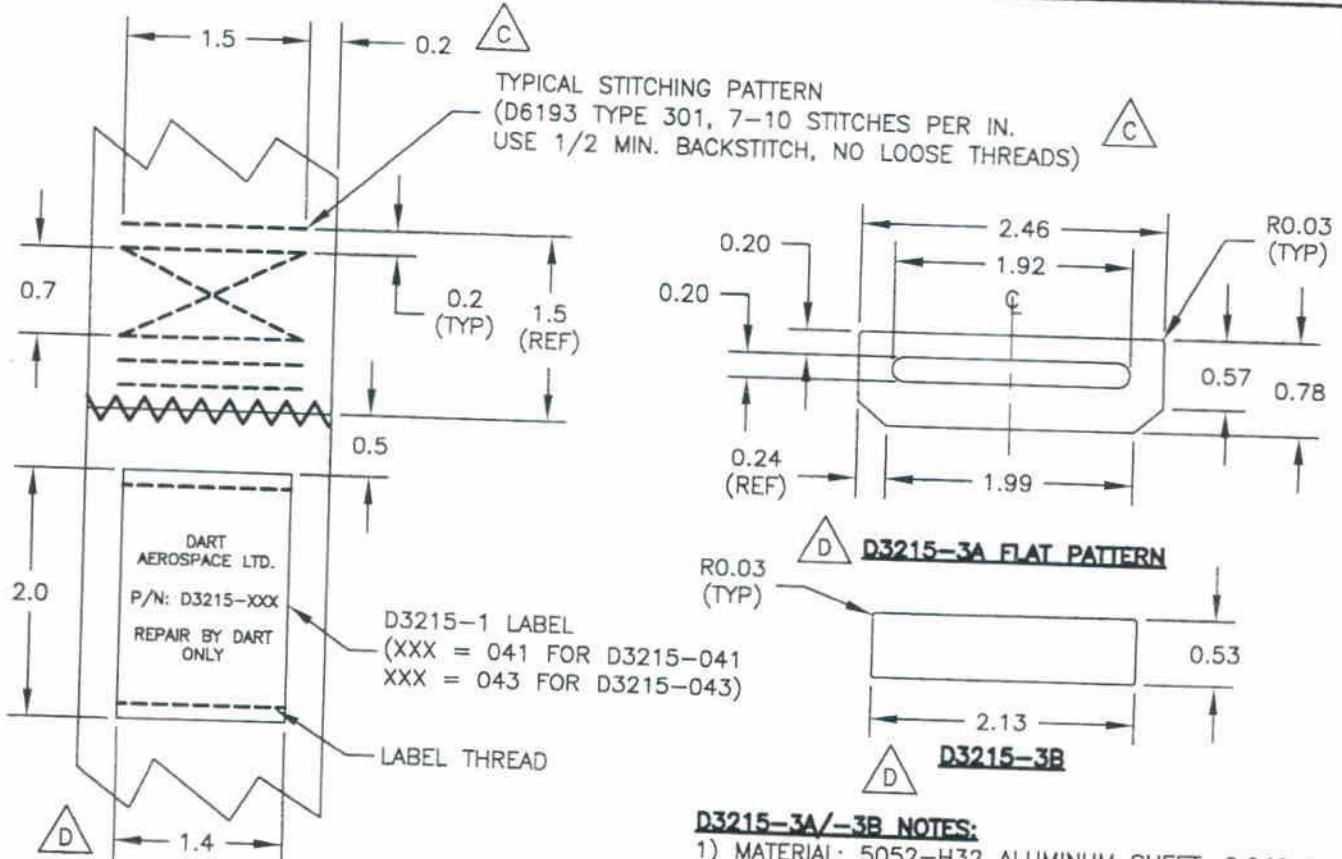
08
7.5

BRIT-17-5

100

DART

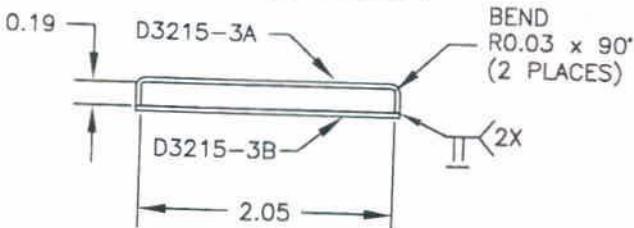
DESIGN <i>GP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>CE</i>	APPROVED <i>H</i>	DRAWING NO. D3215
DATE 07.03.27		REV. D SHEET 3 OF 3 SCALE 3:2

**VIEW A-A****D3215-1 LABEL:**

- 1) MATERIAL: WHITE TYVEK OR WHITE POLYESTER WHICH MEETS FMVSS 302
- 2) USE 1/8 BLACK LETTERING
- 3) CENTER ON BELT WIDTH

RELEASED07 06 07 *[Signature]***GENERAL NOTES:**

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

**D3215-3 WEBBING TIDY****D3215-3 NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANTEX (4.3.5.7)
PER DART QSI 005 4.3

DART AEROSPACE LTD	Work Order:	77324
Description: Webbing Tidy	Part Number:	D3215-3A
Inspection Dwg: D3215 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Measured by:	<u>S</u>	Audited by:	<u>S</u>	Prototype Approval:	N/A
Date:	11-12-15	Date:	11-12-15	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.02.10	New Issue	KJ/RF	
B	06.03.15	Dwg Rev update	KJ/JLM	
C	07.10.24	Dimensions updated per Dwg Rev D	KJ/EC/DD	
D	08.09.10	0.53 dimension removed	KJ/DD	 